

Date: Thursday, 10/18/2007 8:03:12 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BRACKET
Job Number : 35209	
Estimate Number : 11140	
P.O. Number : N/A	Part Number : D32053
This Issue : 10/18/2007 S.O. No. : N/A	Drawing Number : D3205 REV A
Prsht Rev. : NG	Project Number : N/A
First Issue : N/A	Drawing Revision : A
Previous Run : 32823	Material : N/A
Written By : <u>JA 07.10.18</u>	Due Date : 10/24/2007
Checked & Approved By : <u>JA 07.10.18</u>	Qty: <u>29</u> Each
Comment : Est B 05.01.31 Revised Step 10 KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0250X02000	6061-T6 Bar .25" X 2.0"
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Comment: Qty.: 0.2284 f(s)/Unit Total: 0.9135 f(s)

6061-T6 Bar .25" X 2.0"

Material: 6061-T6 (QQ-A-200/8 or QQ-A-250/11 or QQ-A-225/8)(M6061T6B0.250x02.000)

Identify for D3205-3

Batch: 15949 B 07-10-31

(29)

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW

Cut blanks: 2.00" x 0.250" x 2.480" long Bar (+0.030/-0.000)

N/A 07.10.23

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Machine D3205-3 as per Folio FA343 and Dwg D3205

Identify as D3205-3

Deburr and Tumble

 D 07/11/01
 P 07/10/31

(28)

(28)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

B 07-10-31

(20)

5.0	QC8	SECOND CHECK
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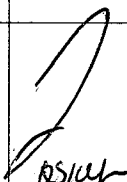
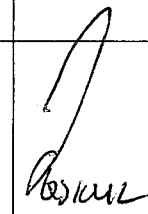
Comment: SECOND CHECK

 07/11/01 x 28
 07/10/31

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/10/09
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07-10-23	3.0	REMOVE ENPLAMJON. this Batch only.	LE 07.10.24 QSI042	Acceptable. Not needed → written in marker @ step 9.0	LE 07.10.24 QSI042	S 07/10/31	LE 07.10.24 QSI042	S 07/10/31
07/11/01	# 3.0	TWO PARTS SCRAP - one has a cut inside the piece - the other has the hole elongated P.C. HUMMING BIRD	 QSI042	Scrap and replace both parts	B 07-11-1	S 07/11/02	 QSI042	S 07/11/01

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 35209

Part Number: D32053

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

MA

07-11-02

(X28)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

m105642

FZ

07/11/06

(28)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M. J.

07/11/06

(28X)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location: 243

7/11/07

50

(28)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/11/07

Job Completion



U 07-11-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

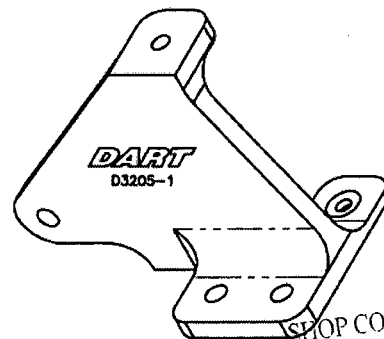
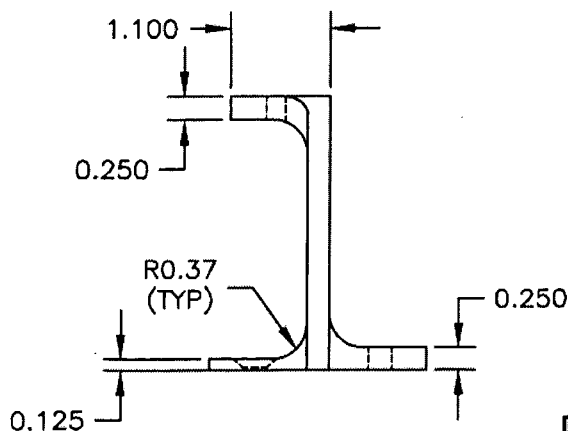
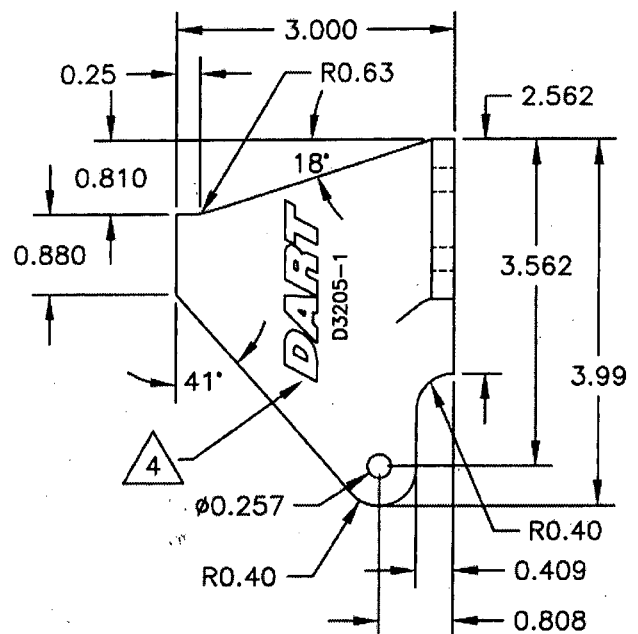
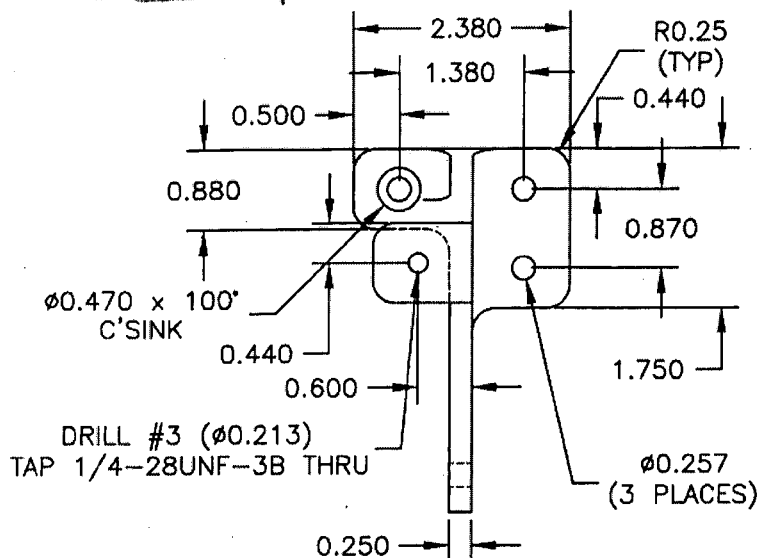
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN RT	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3205	REV. A SHEET 1 OF 2
DATE 04.01.27		TITLE BRACKET	SCALE 1:2
A	04.01.27	NEW ISSUE	

RELEASED
04.04.05



D3205-1 PEDAL BRACKET

NOTES:





- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 7075-T73 (QQ-A-200/11 OR QQ-A-250/12)
OR 2024-T3 (QQ-A-200/3 OR QQ-A-250/4)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) ENGRAVE DART P/N & LOGO AS SHOWN
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE INCHES

SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 35209

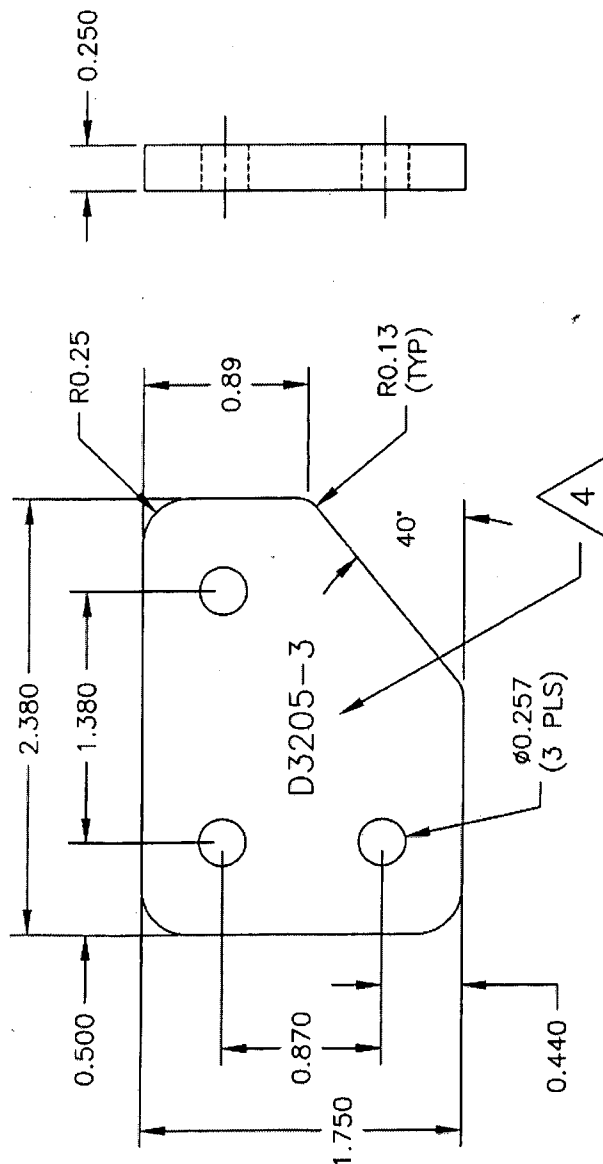
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DESIGN 	DRAWN BY 	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D3205	REV. A SHEET 2 OF 2
DATE 04.01.27		TITLE BRACKET	SCALE 1:1

RELEASED
04.04.05 #



D3205-3 BACK PLATE

NOTES:

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) ENGRAVE PART P/N AS SHOWN
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE INCHES

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SUBJECT TO AMENDMENT
NOTICE

WORK ORDER

~~NC~~

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